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RBSC7048-P
Job Sheet 172192



Part No: RBSC7048-P

Job Qty: 2 ea

Part Name: Portable Bearing Cutter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/13/18

Job Tracking No:

Due Date: 3/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBSC7048-P REV:6 IPP REV A XX/XX/XX NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		3/1/18	0.00	0.00	Start Up Small Fab-4		MU
100	Small Fab	2 pcs		3/2/18	0.08	0.50	Small Fab-9		MU
110	QC	2 pcs		3/2/18	0.00	0.00	QC5		SBS
130	Packaging	2 pcs		3/2/18	0.00	0.00	Packaging3-2	DAS	28
140	QC21-FG	2 Ea		3/2/18	0.00	0.00	QC21	21 9-89	MAY 03 2018

Part Op 100 -- Cut tooth guard 5/8 long as per dwg. note for -29 - Assemble.

Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
5181K95	Tooth Guard (For Shipping), 1-1/8" ID	.1040 ft (.052 ea)	90-Start up Operation	5049357
90477A029	Rotating Flange Nut	2 Ea (1 ea)	90-Start up Operation	5046047
91665A350	Retaining Ring, 7/16" Shaft	2 Ea (1 ea)	90-Start up Operation	5046064
CS112-H2	Crest to Crest Spring	2 (1 ea)	90-Start up Operation	5063335
NTA-1018	Thrust Bearing	2 Ea (1 ea)	90-Start up Operation	50464045/13
RBSC7048-P-1	Spring Tensioner	2 Ea (1 ea)	90-Start up Operation	5055561
RBSC7048-P-11	Stud	2 Ea (1 ea)	90-Start up Operation	5055794
RBSC7048-P-3	Seat	2 Ea (1 ea)	90-Start up Operation	5054941
RBSC7048-P-5	Cutter	2 Ea (1 ea)	90-Start up Operation	5055077
RBSC7048-P-7	Guide	2 Ea (1 ea)	90-Start up Operation	5046406
RBSC7048-P-9	Bushing	2 Ea (1 ea)	90-Start up Operation	5066179
TRB-1018	Thrust Washer	4 Ea (2 ea)	90-Start up Operation	5046046
10137	Small Pistol Case, Plastic	2 Ea (1 ea)	100-Small Fab	5066179
5475A12	Fixed Pin Spanner Wrench	2 Ea (1 ea)	100-Small Fab	5046046

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	5181K95	0	0	0
	90477A029	2	0	0
	91665A350	2	0	0
	CS112-H2	2	0	0
	NTA-1018	2	0	0
	RBSC7048-P-1	2	0	0
	RBSC7048-P-11	2	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPR



QA Closed: _____ Date: _____

Order update only ☐

Work Order: _____	DISPOSITION
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

ENT/PROCESS

Water Jet	☐	Engineering	☐
Prod. Eng. Coord.	☐	Quality	☐
Core/Packaging	☐	Other	☐
Supplier	☐		☐

MRB (QSI042) Approval

Completed By

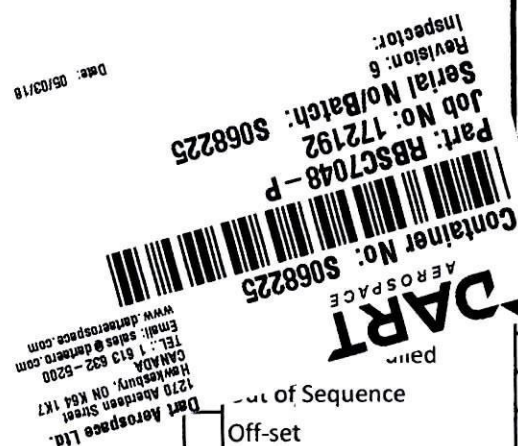
Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

OTHER : _____



Positioned Wrong	☐
Outside Dimensions	☐
Over/Under tolerance	☐
Part Incorrect	☐
Part Lost/Missing	☐
Part Moved	☐
Drawing	☐
Finish	☐
Misread	☐
Turning Sequence	☐

	RBSC7048-P-3	2	0	0
	RBSC7048-P-5	2	0	0
	RBSC7048-P-7	2	0	0
	RBSC7048-P-9	2	0	0
	TRB-1018	4	0	0
100-Small Fab	10137	2	0	0
	5475A12	2	0	0

Part Specifications

Specifications could not be found.

Plex 2/13/18 1:27 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

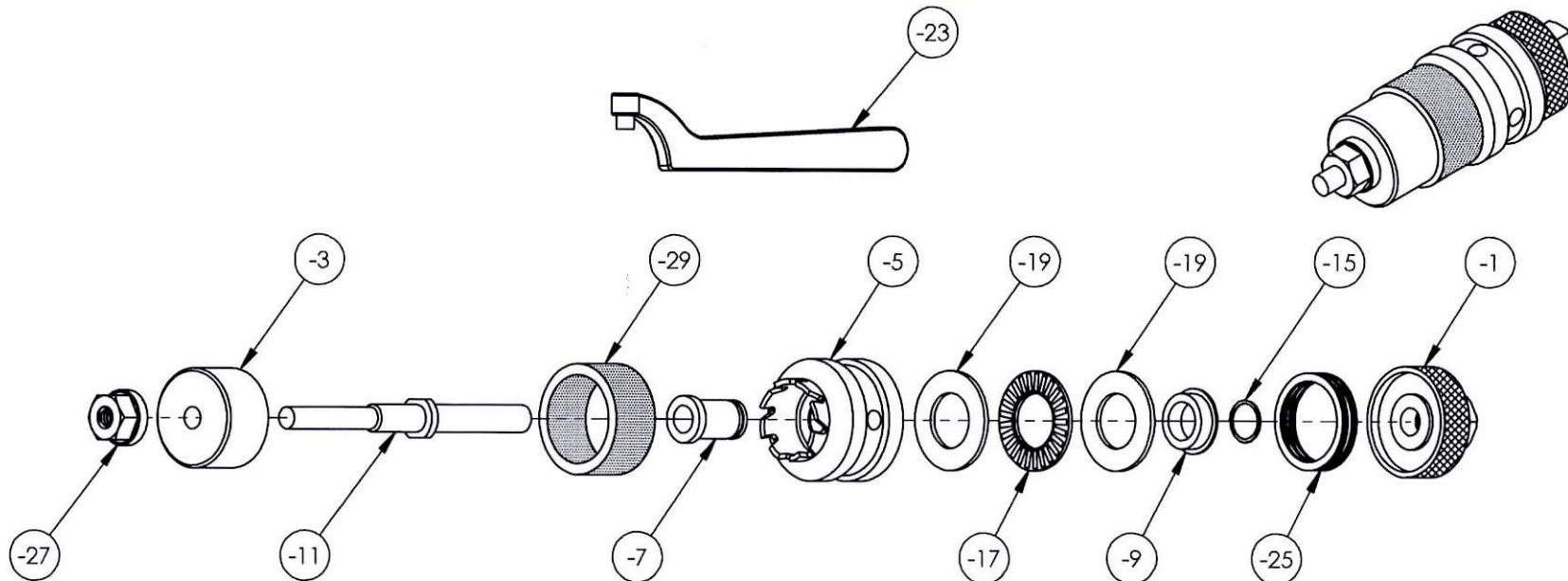
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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BEARINGS AND TOOLS COVERED

BEARING #	TOOL #
406-310-403-101	RBSC7008-P
206-010-470-101	RBSC7028-P
406-312-100-101	RBSC7048-P
412-010-182-103	RBSC7188-P

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED TOOL # RBSC412-010-103-P TO RBSC7188-P TO CLARIFY TOOLING IDENTIFICATION.	11/6/09	WP	DW
2		ADDED NEW BRG. CUTTER RBSC7048-P FOR BEARING #406-312-100-101 PER E.B.	5/2/11	RJC	
3		CH'D -3 B FROM .312, CORRECTED -11 SCALE TO REFLECT PART REPRESENTATION PER S.E.	6/24/11	RJC	RW
4		-5 CH'D DIM SCHEME, REDREW SECTION VIEW.	7/13/2015	BIM	SE
5	15-0470	UPDATED TO NEW DRAFTING STANDARDS. ADDED NEW BEARING MODELS.	7/13/2015	SM	JAG
6	16-0112	UPDATED TO NEW STANDARD. ADDED CASE RSR GROUP #10137 TO BOM. -1 CH'D MAT'L WAS 1018 IS 1018/1020 CR. CH'D DIMS WAS Ø.625 IS Ø.63, WAS 5/16-24 UNF IS 5/16-24 UNF-2B. ADDED SPEC. -3 CH'D MAT'L WAS 4140 Q&T RND BAR IS 4140/4142. CH'D DIM WAS .032 X 45° IS .03 X 45°, ADDED HEAT TREAT AND SPEC. -5 CH'D DIMS WAS R.030 IS R.03, WAS .015 X 45° IS .02 X 45°, WAS R.015 MAX IS R.02 MAX, ADDED DIM 4X Ø.219 ±.23 EQUALLY SPACED. ADDED SPEC. -11 CH'D MAT'L WAS 4140 Q&T IS 4140/4142. ADDED HEAT TREAT AND SPEC. CH'D DIMS WAS 1/4-20 MACHINE THREADS IS 1/4-20 UNC-2A, WAS 5/16-24 MACHINE THREADS IS 5/16-24 UNF-2A.	8/11/2016	DEW	SM



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SPRING TENSIONER	1018/1020 CR		2
			-3	1	SEAT	4140/4142		3
			-5	1	CUTTER	O-1		4
			-7	1	GUIDE	BRONZE		5
			-9	1	BUSHING	BRONZE		6
			-11	1	STUD	4140/4142		7
		B/O	-15	1	SPIRAL EXTERNAL RETAINING RING	STEEL	Ø7/16 SHAFT (MCMaster-CARR # 91665A350)	1
		B/O	-17	1	THRUST BEARING	STEEL	Ø 5/8 ID. X 1-1/8 OD. X 5/64 (APPLIED # NTA-1018)	1
		B/O	-19	2	THRUST WASHER	STEEL	Ø 5/8 ID. X 1-1/8 OD. X 1/16 (APPLIED # TRB-1018)	1
		B/O	-23	1	FIXED PIN SPANNER WRENCH	STEEL	Ø 1-1/4 OD. X Ø 13/64 PIN (MCMaster-CARR # 5475A12)	1
		B/O	-25	1	CREST TO CREST SPRING	STEEL	SMALLEY CO. # CS112-H2	1
		B/O	-27	1	ROTATING FLANGE NUT	STEEL	1/4-20 ROTATING FLANGE NUT (MCMaster-CARR # 90477A029)	1
		B/O	-29	1	TOOTH GUARD (FOR SHIPPING ONLY)	VINYL	SEE -5 ØB PAGE 4 FOR INSIDE DIA, OF TUBE X 5/8 LENGTH	1
		B/O	-31	1	CASE	PLASTIC	(RSR GROUP # 10137)	N/S

		TITLE RBSC7###-P SERIES PORTABLE BEARING CUTTERS FOR BELL BEARINGS	
		DWG NO. RBSC7###-P	REV 6
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
DRAWN BY: MACKOVJAK		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: DUERFELDT		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT			
SCALE 1:2	DATE 7/13/2015	SHEET 1 OF 7	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					